NAV 25 Soldering Controls

SECTION I – Procedure:

A 1.	Identify the standard the supplier uses for performing soldering. ____MIL- STD 454 ____IPC-A-610 ____OTHER IF Other, Specify:	
A 2	a. Does a written detailed procedure exist and is it utilized for the soldering process? Identify procedure number and revision.	___Yes ___No ___N/A
	b. Does a written detailed procedure exist for assembly of components prior to soldering? Identify procedure number and revision.	___Yes ___No ___N/A
A 3.	Are procedures readily available?	___Yes ___No ___N/A
A 4.	Are inspection procedures utilized for soldering? Identify procedure number and revision;	___Yes ___No ___N/A
A 5.	a. Are inspection and manufacturing personnel trained in use of procedures?	___Yes ___No ___N/A
	b. Is this recorded and part of employee's file'?	___Yes ___No ___N/A
A 6.	Are soldering procedures written based on contract-invoked requirements or generic and company based standards?	___Yes ___No ___N/A
A 7	a. Is the procedure approved by the Customer? List Reference Approval Number, if applicable:	___Yes ___No ___N/A
	b. Does the procedure require review/approval by the government?	___Yes ___No ___N/A
A 8.	Are procedures/work instructions adequate for control of:	___Sat ___Unsat
	a. (Proper Equipment) etc.	___Yes ___No ___N/A
	b. (Proper Materials) etc.	___Yes ___No ___N/A

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A 9.	What type of tools, mechanical strippers, chemical strippers, thermal strippers, holding devices, bending tools, clinching tools are required in the use of the procedures? Specify sample of tools	
A 10.	Does procedure include system for identification of inspection status on parts and documentation? (E.g. inspection stamp)	___Sat ___Unsat
SECTION II – Record Review		___Sat ___Unsat
A 11.	Identify inspection methods used to verify conformance with procedures and standards	___Sat ___Unsat
A 12.	What inspection documents exist and are they maintained to confirm inspection process was performed?	___Yes ___No
	a. Are inspection documents properly completed and maintained?	___Yes ___No
	b. Review and record number of samples: _____	
A 13.	Is traceability maintained for material, which has been soldered?	___Yes ___No ___N/A
A 14.	Is inspection data reviewed and accepted by qualified personnel?	___Yes ___No ___N/A
A 15.	Are all tools, gages, meters, utilized for monitoring and/or inspection a part of the manufacturer's calibration program?	___Yes ___No ___N/A
A 16.	Are certifications for raw materials used in soldering process reviewed for acceptance and maintained on file for review?	___Yes ___No ___N/A
A 17.	Are adequate inspection work records maintained?	___Yes ___No ___N/A
A 18.	Are shop traveler and work records traced to the operator/inspection personnel?	___Yes ___No ___N/A
SECTION III – OBSERVATION OF SOLDERING PROCESS Detailed observation of solderer (complete one section for each solderer observed). NOTE: if determined to be N/A, provide explanation.		___Sat ___Unsat
A 19.	Identify process being observed. What is being soldered?	

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	a. Solderer identification:(name, badge or clock #, shift)	
	b. Basic material(s) being soldered, pc board, wire, assembly, etc.	
	c. Identify soldering material, solder type, flux, class, etc.	
	d. Is the solderer qualified for observed soldering procedure?	___Sat ___Unsat ___N/A
	e. Is the solderer familiar with details of the procedure?	___Sat ___Unsat ___N/A
	f. Procedure number:	
	g. Is it readily available to the solderer and inspector?	___Sat ___Unsat
A 20.	Are their adequate methods of segregating accepted and rejected materials in use?	___Sat ___Unsat
A 21.	Do solder rolls and raw materials have traceable markings on containers. What types of solders are used? (List)	___Sat ___Unsat
A 22.	Are soldering tools ions correct wattage for ESD or sensitive components.	___Sat ___Unsat
A 23.	Are work areas clean from debris and separate from other areas for soldering operations.	___Yes ___No
A 24.	Are exhaust equipment utilized in soldering areas to provide fresh air for personnel.	___Yes ___No
A 25.	Do controls exist for handling and disposing of solder waste?	___Yes ___No

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Additional Comments/Concerns: